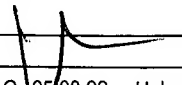
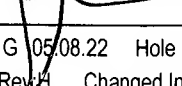


Date: Wednesday, 5/16/2007 2:12:53 PM  
 User: Chantal Lavoie

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 32427	
Estimate Number : 10312	
P.O. Number : N/A	Part Number : D2646
This Issue : 5/16/2007 S.O. No. : N/A	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 32375	Material : N/A
Written By : 	Due Date : 6/5/2007
Checked & Approved By : 	Qty: 50 Um: Each
Comment : Est: G 05/08/22 Hole size revised in Step 5 KJ/JLM Est Rev: H Changed Inserts 07-02-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3794

1-Spin as per Dwg D2646

2-Material release note required

C207105114

(50)

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)  
 AFT-CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

07/06/05 (50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

070606 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .250" and sink as per Dwg D2646.

3-Deburr

297

07.06.11

07/06/13 (50)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 17/06/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 2:12:53 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32427

Part Number: D2646

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*MD*

07-06-15

50

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m 104 144*

*BR/MK 07-06-19*

50

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL*

07/06/19

50

9.0	ALS71032130	Insert
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch: *m 103495*

*\**

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

*FL*

07/06/19

50

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*En/Don 06-20*

50

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-14*

*HL*

07-06-20

50

13.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*07/06/20*

50

Job Completion



*U 07-06-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

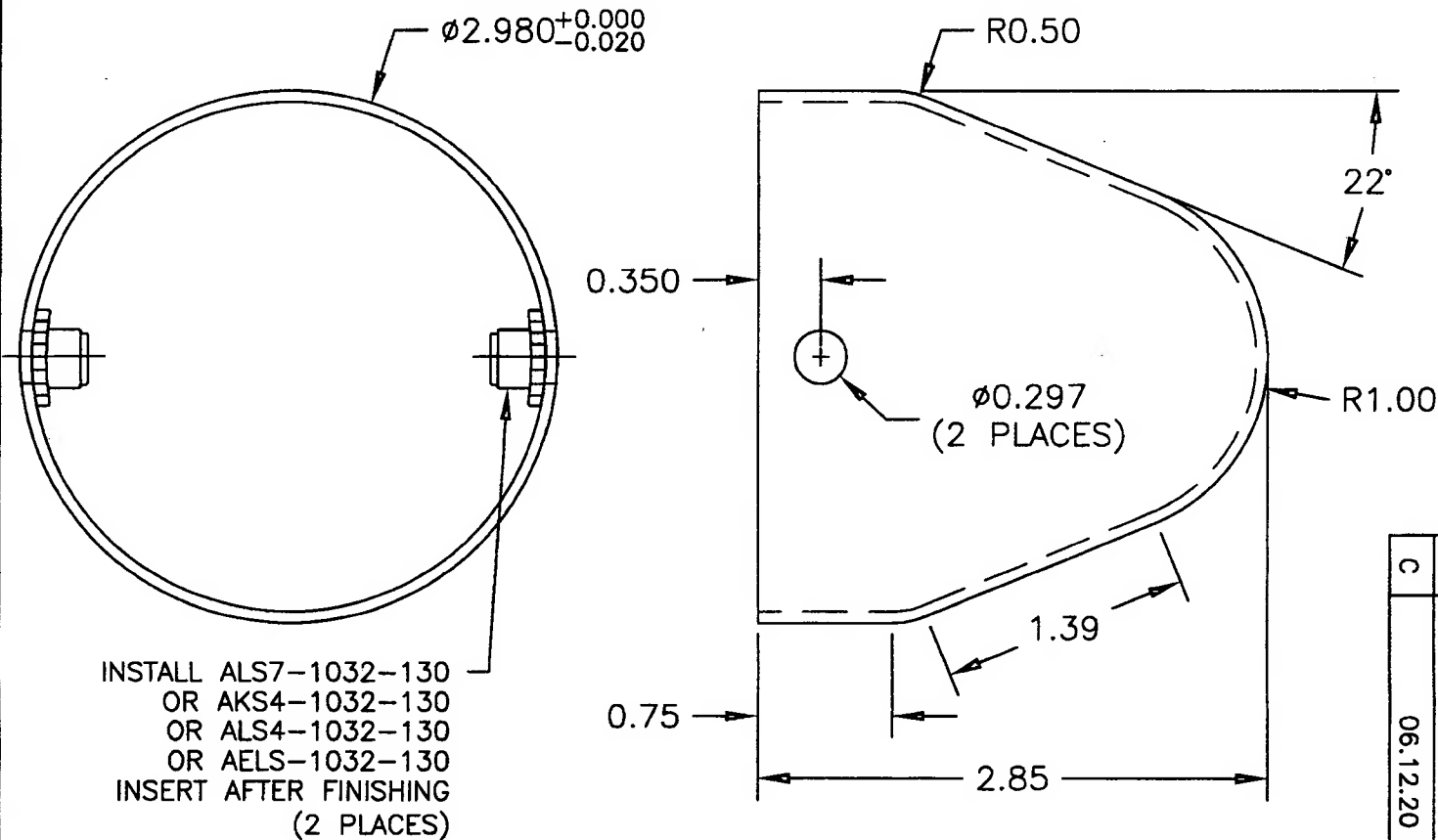
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DS	DRAWN BY	GH	DART AEROSPACE USA, INC.	REV. C
CHECKED	GH	APPROVED	GH	DRAWING NO. D2646	SHEET 1 OF 1
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1
A	97.03.25	NEW ISSUE			
B	05.04.01	CHANGE TO CLOSED INSERTS			
C	06.12.20	CHANGE TO OPEN ENDED INSERTS			



INSTALL ALS7-1032-130  
OR AKS4-1032-130  
OR ALS4-1032-130  
OR AELS-1032-130  
INSERT AFTER FINISHING  
(2 PLACES)

#### D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-O 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
07.02.12



1480 Manheim Pike  
Lancaster Pa 17601

# CERTIFICATION OF TEST RESULTS

<b>SOLD TO</b>	COPPER & BRASS SALBS INC 22355 WEST ELEVEN MILK ROAD SOUTHFIELD, MI 48034	<b>SHIP TO</b>	COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212	<b>CERT NO</b> 0000598687
	<b>DATE</b> 10/26/2004			
				<b>SKID NO</b> 322296
				<b>SKID WGT</b> 9,760
				<b>PAGE</b> 1 OF 1

<b>ORDER NO</b>	LB4176	<b>PO NO</b>	C99792			<b>MILL FINISH</b> NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
<b>ITEM NO</b>	1	<b>PART NO</b>	050393-8			
<b>ALLOY</b>	1100	<b>TEMPER</b>	0	<b>FORM</b>	COIL	
<b>GAUGE</b>	06300	<b>WIDTH</b>	48.0000	<b>LENGTH</b>	0.0000	

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI  
TAIL ULTIMATE STRENGTH 12.6 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI  
HEAD ELONGATION (G.L. = 2 IN) 35.5 %  
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 O, AMS 400TH 1100 O,  
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL  
\*\* END OF CERTIFICATION \*\*

*Handwritten:*  
HAW  
Henry @ SHR  
C/O  
Sorel  
LTS

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JEFF FREEDY, LAB SUPERVISOR





# Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7  
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

## INSPECTION REPORT

Date: June 4/07  
Customer: Dart Aerospace  
Packing Slip: 31273

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By:
B32375	16	1A61100	N/A	✓	
B32427	50	1A61100	N/A	✓	

Notes:

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Material Certification Attached: Yes.

